

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023122**Date Inspected:** 27-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gang Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

BAY # 14

This QA Inspector randomly observed the following work in progress.

OBG 14 EAST

This QA Inspector performed randomly Visual Inspection on OBG Segment 14 east. The member is identified as OBG Segment 14 East has been moved from bay 14 to towards Trial assembly area by ZPMC personal. For more information see attached photos.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

SHIELDED METAL ARC WELDING PROCESS.

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This QA Inspector observed ZPMC qualified welding personnel identified as 067947 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 13 AW. Joint identified as SEG3019Q-261. ZPMC QC Identified as Zhu Lin. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS -B-P-2114-FCM-1.

FLUX CORED ARC WELDING PROCESS.

This QA Inspector observed ZPMC qualified welding personnel identified as 220063 Perform Flux Core Arc Welding (FCAW) on OBG Segment 13 AW. Joint identified as SEG3007H-001-133. ZPMC QC Identified as Zhu Lin. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 220066 Perform Flux Core Arc Welding (FCAW) on OBG Segment 13 AW. Joint identified as SEG3007K-001-056. ZPMC QC Identified as Zhu Lin. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 067103 Perform Flux Core Arc Welding (FCAW) on OBG Segment 14 West. Joint identified as SEG3020B-055. ZPMC QC Identified as Zhu Lin. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2232-ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
